

Work Order ID 68333

Tuesday, April 12, 2011 10:00:53 AM



Page 1

Item ID:	D3065-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	4/12/2011	Start Qty:	40.00	Cust Item ID:		
Required Date:	4/18/2011	Req'd Qty:	40.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	4-04-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D necessary		<input checked="" type="checkbox"/> Dwg Rev: <u>R</u>	<input checked="" type="checkbox"/> Prog Rev: <u>R</u>	<input type="checkbox"/> 2-Debur if				
2624.040									

B11-5-2

(48)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-5-2

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5/11/05/02

counts
(48)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

Revision ID:

Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00

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Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140  Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3065								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

n/AS

SB 11/05/03

48

8 11/05/04

48

W/O:		WORK ORDER CHANGES						
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Item ID: D3065-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				48	0	22	11/05/06
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				48	0	22	11/05/06
180 Packaging Packaging	Identify as per dwg & Stock Location <i>GA</i> Memo	0.00 0.00				48	0	22	11/05/06

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Page 4

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Setup Start



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Stop



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Start Date: 4/12/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/98

11-05-6
48

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Picklist Print

Tuesday, April 12, 2011 10:01:00 AM

Page 1

Work Order ID: 68333



Parent Item: D3065-3



Parent Item Name: Step Spacer



Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C02.11.010Incorporated D3066-1 IPP0KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM0

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 		Purchased	No			100	sf	97.0000	0.2178	9.170526		10.5	
												B11-5-2	

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

97

112291

0.5

112331

32.5

113162

64

113162

48

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SHOP COPY
RETURN TO
ENGINEERING

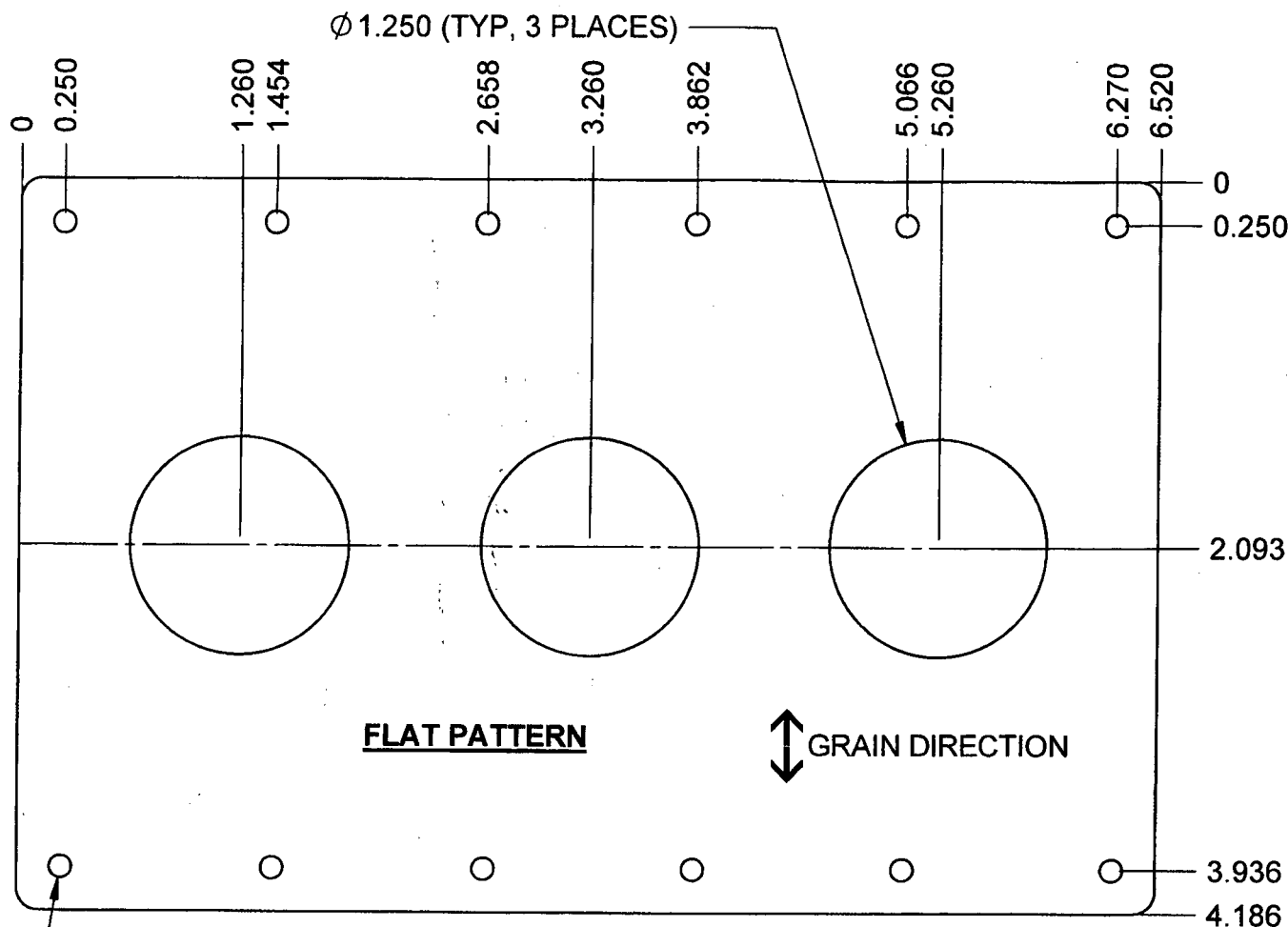
UNCONTROLLED
SUBJECT TO

WITHOUT NOTICE
WORK ORDER

NO. 48333 1211-04-12



DESIGN CP	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3065	REV. B
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SHEET 3 OF 5 SCALE 1:1

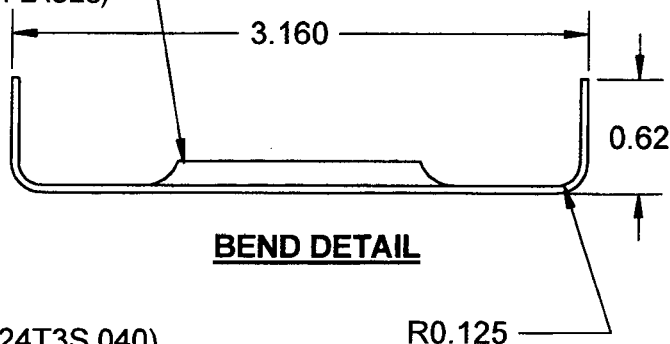


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 [Signature]



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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